

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014536**Date Inspected:** 16-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng wei/ Zhou cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4F-026 located on PCMK DP3053-001 of Segment 12AW welder is identified as 037723. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 4F-036 located on PCMK SEG3004V of Segment 12AW welder is identified as 202122. ZPMC QC is identified as Mr. Zhong yong gang . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM.

FCAW welding of weld joint 3G-003 located on PCMK SEG3005E of Segment 12BW welder is identified as 067949. ZPMC QC is identified as Mr. Zhong yong gang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

BAY#16

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Tower Facade.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The weld designations reviewed are as follows:

NWIT-005748.

SD1-A230-3/4.

SD1-A232-3/4.

SD1-A235-3/4.

SD1-A237-3/4.

SD1-A238-3/4.

SD1-A240-3/4.

SD1-A242-3/4.

OUTSIDE SHOP

11AW

Fit-up of Drain plate and X37 plates are in progress.

BAY#19

FCAW welding of weld joint 2G-055 located on PCMK SB019-070 of SB70E welder is identified as 062749. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-067 located on PCMK SB015-068 of SB68E welder is identified as 062788. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of repair weld joint 2G-001 located on PCMK SB012-056 of SB56W welder is identified as 062761. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G(2F)-repair and WR12895.

Re work of Bike path BK004A-004 , grinding started today. The location where BKX11B stiffener connects with bearing plate and deck plate fillet weld location ZPMC difficult to grind because of no access.

The weld is identified as

BK004A8-004-014,016,020.

BK004A6-004-016,014,020.

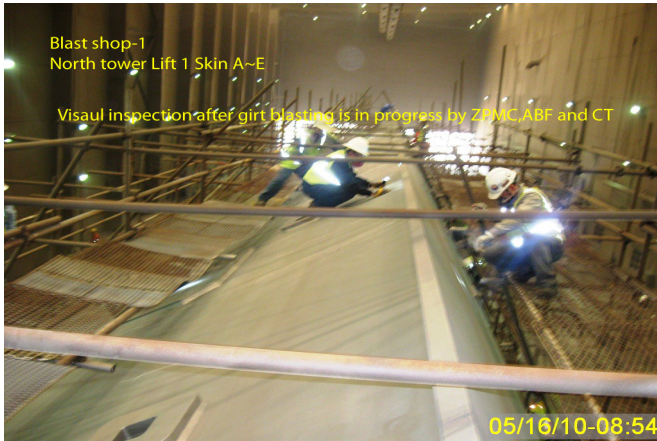
BLAST SHOP

Visual Inspection after Blast at North Tower Lift -1 This Quality Assurance (QA) Inspector performed random visual inspection of North Tower lift -1 all skin plate (A to E) height 0 meter to 47.6 meter after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
